



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-567-141
Job Sheet 183447



Part No: D350-567-141

Job Qty: 1 ea

Part Name: Floor Window Close Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER ECN12-511 DD
VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC IPP REV:D 13.04.01 AS PER DSI9590
REV:E DD VERF:JLM IPP REV :E AS PER DSI9590 REV F JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/15/18	10/15/18	0.00	0.00	Start Up Stores/Pkg-2		SEP 27 2018
110	Packaging	1 pcs	10/15/18	10/15/18	0.00	0.00	Packaging1-3		SEP 27 2018
120	QC	1 pcs	10/15/18	10/15/18	0.00	0.00	QC4		OCT 12 2018
130	Packaging	1 pcs	10/15/18	10/15/18	0.00	0.00	Packaging3-1		OCT 15 2018
135	DC	1 pcs	10/15/18	10/15/18	0.00	0.00	DC		OCT 15 2018
140	QC21-FG	1 Ea	10/15/18	10/15/18	0.00	0.00	QC21		OCT 15 2018

Part Op 130 - Identify and pack for shipping as per PPP D350-567-141 Location:FG033
Descriptions: 135 - Photocopy bluefile & type labels per PPP D350-567-141 CHG004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	7 Ea (7 ea)	90-Start up Operation	5056462
AN525-10R6	Screw	2 Ea (2 ea)	90-Start up Operation	514137307
AN525-832R7	Screw	2 Ea (2 ea)	90-Start up Operation	5089346
D3802-1	Window Seal (\$ Per Foot)	2 ft (2 ea)	90-Start up Operation	5104211
D4434-041	Fwd Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5092241
D4434-047	Cover Assembly	1 Ea (1 ea)	90-Start up Operation	5068704
D4435-045	T/R Bellcrank Cover Assembly	1 Ea (1 ea)	90-Start up Operation	5074017
D4435-9	Bracket	2 Ea (2 ea)	90-Start up Operation	5110402
D4436-041	Aft Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5083014
D4441-1	Rubber Seal	2 ft (2 ea)	90-Start up Operation	5092167
MS21042L06	Nut	7 Ea (7 ea)	90-Start up Operation	5095637
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5044234
MS21042L3	Nut	5 Ea (5 ea)	90-Start up Operation	5094592
MS21059L3	Nut Plate	2 Ea (2 ea)	90-Start up Operation	5041352
MS35206-229	Screw	7 Ea (7 ea)	90-Start up Operation	5067268
NAS1149F0332P	Washer	12 Ea (12 ea)	90-Start up Operation	5103086
NAS1149FN616P	Washer	14 Ea (14 ea)	90-Start up Operation	5069085
NAS1149FN816P	Washer	2 Ea (2 ea)	90-Start up Operation	5117316-25

Job Allocations

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Step _____		 Container No: S114159 Part: D350 - 567 - 141 Job No: 183447 Serial No/Batch: S114159 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH92 - 18 Issue for FAA STC SH989NE 09/06/30, FAA STC S		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">Engineering</td> <td style="width: 50%;">☐</td> </tr> <tr> <td>Quality</td> <td>☐</td> </tr> <tr> <td>Other</td> <td>☐</td> </tr> <tr> <td colspan="2">MRB (QSI042) Approval</td> </tr> <tr> <td colspan="2">Completed By</td> </tr> <tr> <td colspan="2">Lead hand / Supervisor Approval Verification</td> </tr> <tr> <td colspan="2">QC / QA Coordinator Approval</td> </tr> </table>			Engineering	☐	Quality	☐	Other	☐	MRB (QSI042) Approval		Completed By		Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval																																																																	
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OTHER : _____																																																																																				

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-3A	7	338	0
	AN525-10R6	2	164	0
	AN525-832R7	2	99	0
	D3802-1	2	153	0
	D4434-041	1	5	0
	D4434-047	1	10	0
	D4435-045	1	4	0
	D4435-9	2	10	0
	D4436-041	1	6	0
	D4441-1	2	551	0
	MS21042L06	7	140	0
	MS21042L08	2	2,942	0
	MS21042L3	5	3,240	0
	MS21059L3	2	212	0
	MS35206-229	7	109	0
	NAS1149F0332P	12	3,305	0
	NAS1149FN616P	14	229	0
	NAS1149FN816P	2	192	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : ☐											

REFERENCE ONLY

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. Shepherd
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PAGE 1 OF 1

Description: FLOOR WINDOW CLOSEOUT

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